

Date: Tuesday, 3/21/2006 10:25:42 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	BRACKET
<b>Job Number</b> :	26303		
<b>Estimate Number</b> :	10384		
<b>P.O. Number</b> :	N/A	<b>Part Number</b> :	D3195043
<b>This Issue</b> :	3/21/2006	<b>S.O. No.</b> :	N/A
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3195 REV A
<b>First Issue</b> :	N/A	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	26050	<b>Drawing Revision</b> :	A
	<b>Type</b> :	<b>Material</b> :	N/A
	MACHINED PARTS	<b>Due Date</b> :	3/28/2006
<b>Written By</b> :	<u>SER COMMENT BELOW</u>		<b>Qty:</b> 40 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	<u>[Signature]</u>		
<b>Comment</b> :	Est Rev:A New Issue 05-11-08 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1500X01250	6061-T6 Bar 1.5" x 1.25"
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**Comment:** Qty.: 0.3150 f(s)/Unit Total : 12.6000 f(s)  
 Material: 6061-T6/T651 (QQ-A-200/8) or (QQ-A-225/8) or (QQ-A-250/11)  
 (M6061T6B1.250x1.500)  
 Identify for D3195-3 *M100384 X*  
 Batch: *En 06/03/24* (40)

2.0	BAND SAW	BAND SAW
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**Comment:** BAND SAW  
 Cut blanks: (1.250" x 1.500") x 3.60" long

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1  
 1-Machine D3195-3 as per Folio FA334 and Dwg D3195 Identify as D3195-3  
 2-Deburr *SA 06.03.25* (41)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	----------------------------------------



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE *SA 06.03.25* (41)

5.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK *BA 06.03.27* 41

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 3/21/2006 10:25:42 AM  
User: Linda Lacelle

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 26303

Part Number: D3195043

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m 06-03-28

(40)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

a.m 06-03-30

(40)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 06/04/04 (40)

9.0

D31957

Pad



Comment: Qty.: 1.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1

D3195-7

PAD

(30) B 26059  
(11) B 26337

SB 06/04/04 21/

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Lightly Sand bonding surface

2-Bond D3195-7 into D3195-13as per Dwg D3195

A/R Contact Cement

M 100008

SB 06/04/04

(40)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2060404

(40)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

st13y

e/4/4 (41)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/04/06

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/21/2006 10:25:42 AM  
User: Linda Lacelle

## Process Sheet

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Drawing Name: BRACKET

Job Number: 26303

Part Number: D3195043

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL  
Inspection Level 21

DD 06/04/06 (41)

Job Completion



U 06-04-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

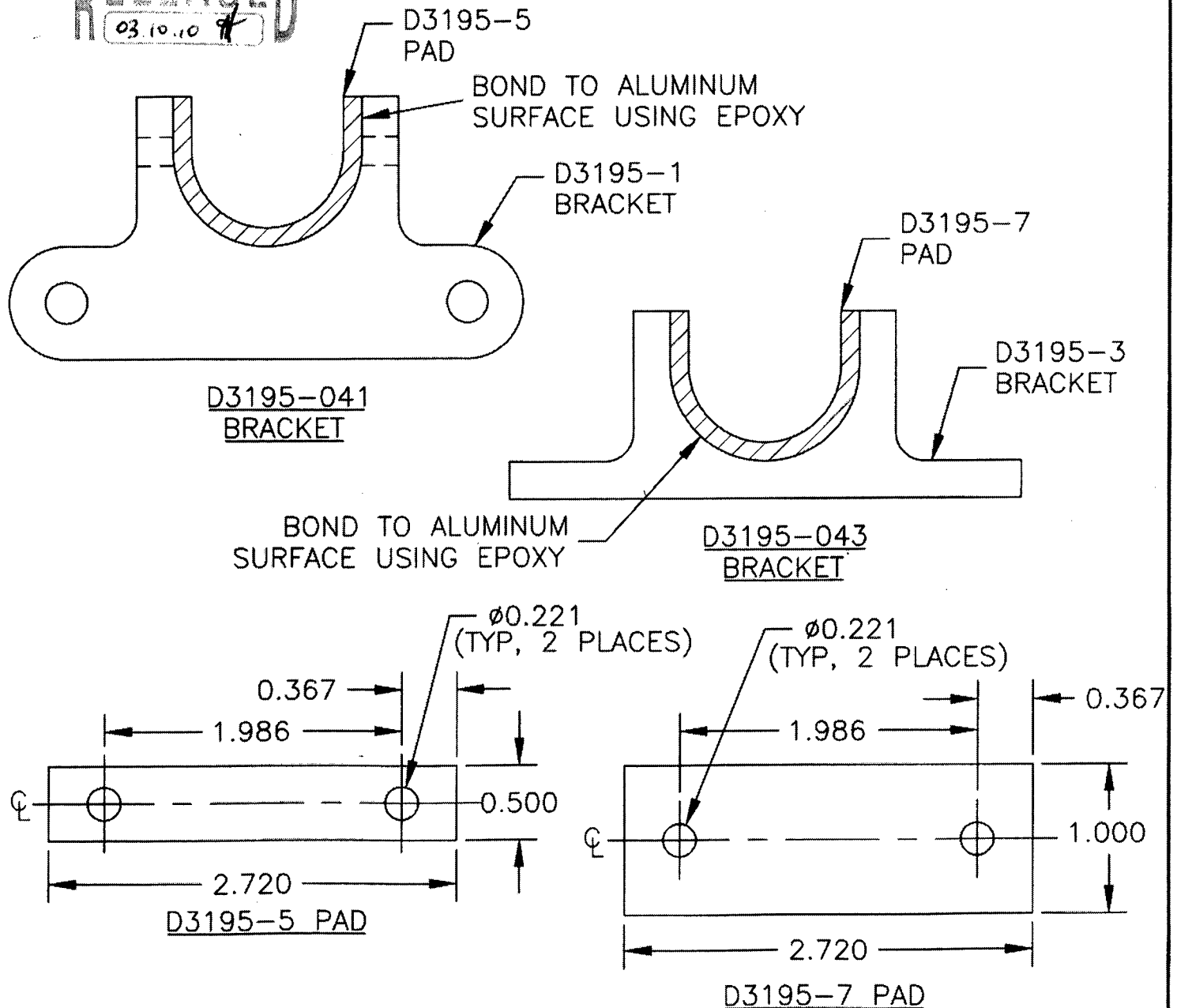
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3195	REV. A SHEET 1 OF 3
DATE 03.06.23		TITLE BRACKET	SCALE 1:1
A	03.06.23	NEW ISSUE	

RELEASED  
03.10.10 *#*



#### D3195-5 & D3195-7 PAD

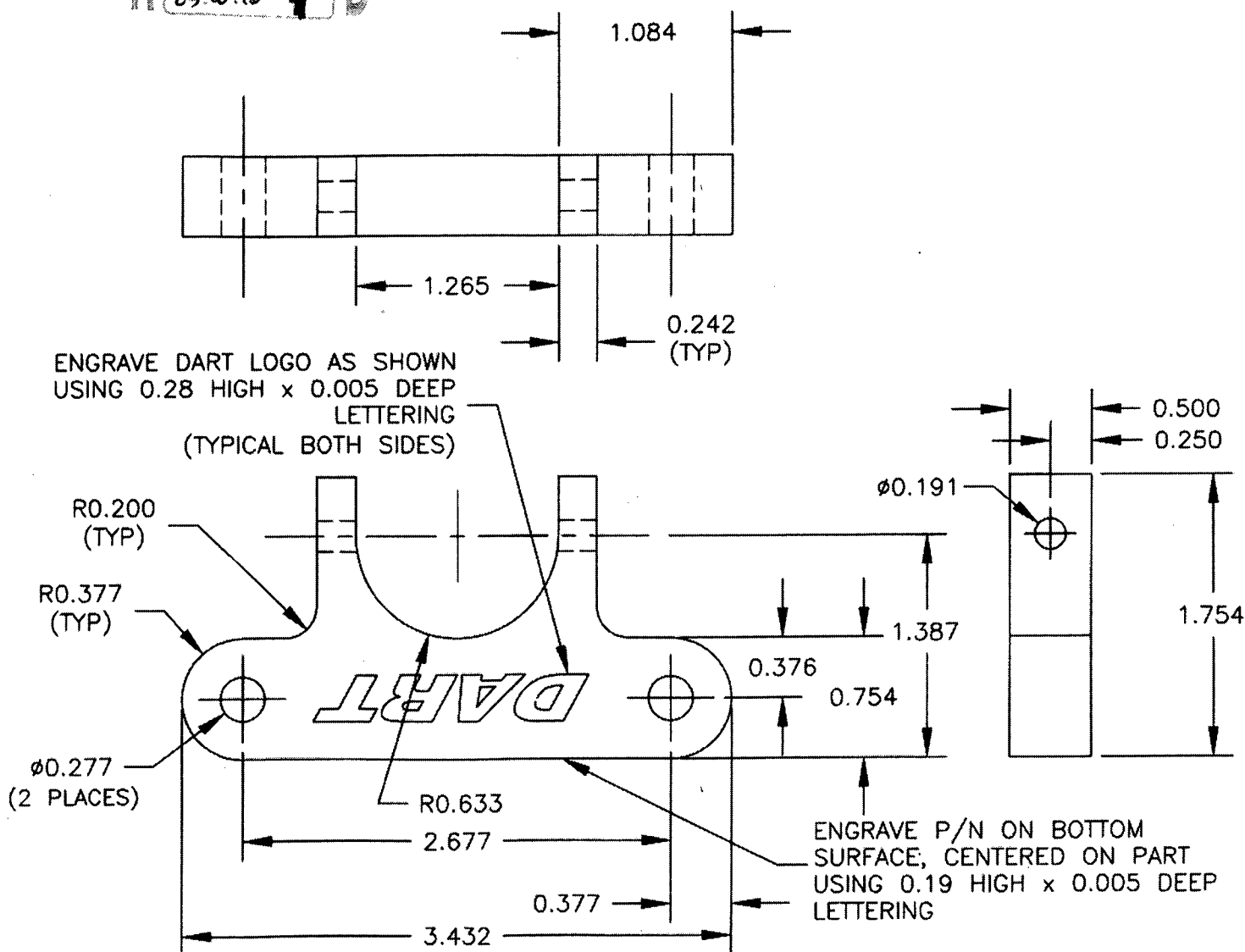
- 1) MATERIAL: 60 DUROMETER NEOPRENE 1/8" THICK  
(POSSIBLE SUPPLIERS, ACCURATE RUBBER)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 3) ALL DIMENSIONS ARE IN INCHES

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**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3195	REV. A SHEET 2 OF 3
DATE 03.06.23		TITLE BRACKET	SCALE 1:1

**RELEASED**  
03.10.10**D3195-1 BRACKET**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)  
(REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

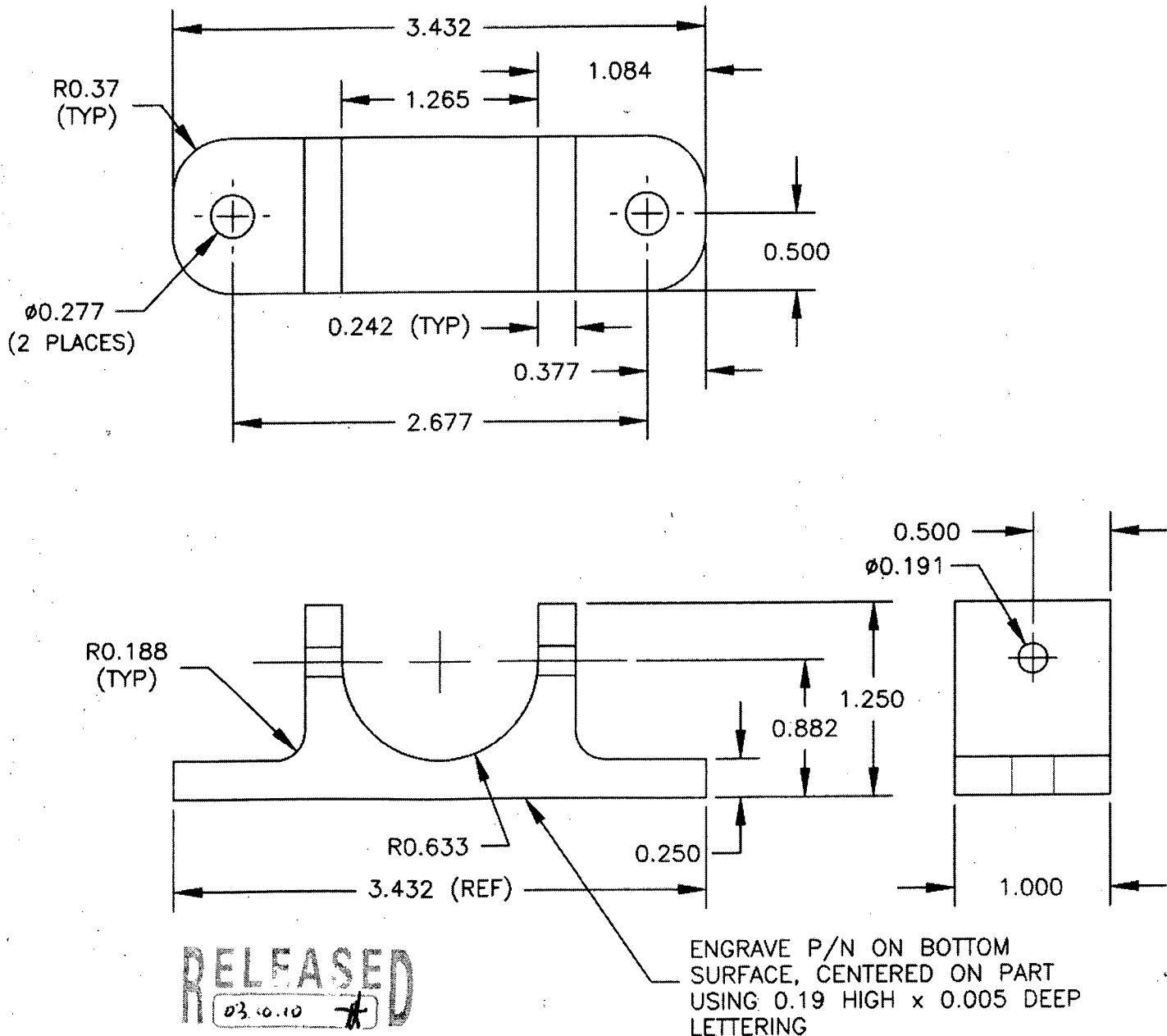
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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3195	REV. A SHEET 3 OF 3
DATE 03.06.23		TITLE BRACKET	SCALE 1:1



#### D3195-3 BRACKET

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)  
(REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	
<b>Description:</b> Bracket		<b>Part Number:</b>	D3195-3
<b>Inspection Dwg:</b> D3195 <b>Rev:</b> A		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.432	+/-0.010	3.434	/			
1.265	+/-0.010	1.260	/			
R0.37	+/-0.030	R.37	/			
Ø0.277	+0.005/-0.000	Ø.279	/			
2.677	+/-0.005	2.678	/			
0.242	+/-0.010	.246	/			
0.377	+/-0.010	.378	/			
0.500	+/-0.010	.500	/			
R0.188	+/-0.010	R.1875	/			
0.250	+/-0.010	.249	/			
0.882	+/-0.010	.879	/			
1.250	+/-0.010	1.248	/			
0.500	+/-0.010	.500	/			
Ø0.191	+0.005/-0.000	Ø.192	/			
1.000	+/-0.010	1.001	/			

<b>Measured by:</b> SD	<b>Audited by:</b> BG	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 06.03.25	<b>Date:</b> 06.03.26	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D412-702-011/-013)	KJ/RF	
B	05.04.26	R0.37 was R0.037; 1.084 removed	KJ/JLM	